

5/26

DART AEROSPACE LTD	Work Order:	23688
Description: Lug Bracket	Part Number:	D3046-041
Drawing: D3046 rev.A	Qty:	14

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	KJ	05.06.27	14
2	STORES	Pick: Qty Part Number Description Batch 1 D3046-1 Lug Bracket B15069 1 D3046-3 (Bell p/n 206-052-106-1) N/A Return Authorization # R390 Bell original batch# 37583	3AD	05/07/04	4
3	METAL	Transfer drill holes from D3046-3 into D3046-1 as per Dwg D3046	SMO	05/07/04	4
4	METAL	Counter sink inside holes of D3046-1 as per Dwg D3046	SB	05/07/04	4
5	METAL	Deburr	SB	05/07/04	4
6	QC	Inspect Level 5	SB	05-07-04	4
7	METAL	Powder coat D3046-1 & D3046-3 white (4.3.5.2) as per QSI 005	MM	05 07 04	4
8	QC	Inspect Level 3	SB	05/07/05	4
9	STORES	Pick: Qty Part Number Description Batch 10 MS20426AD5-7 Rivet H3876	SB	05/07/05	4
10	METAL	Assemble as per Dwg D3046	SB	05/07/05	4
11	QC	Inspect Level 5	SB	05-07-05	4
12	METAL	Powder coat white (4.3.5.2) as per QSI 005	MM	05 07 05	4
13	QC	Inspect Level 3	CD	05/07/05	4
14	STORES	Identify and stock	CD	05/07/05	4
15	EXPEDITING	Close W/O Cost / part 49.31 sub 05/07/06 60.25	KJ	05.07.15	4

Rev	Date	Change	Revised By	Approved
A	01.08.27	New issue	SM	EE

RELEASED

01-08-27 E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

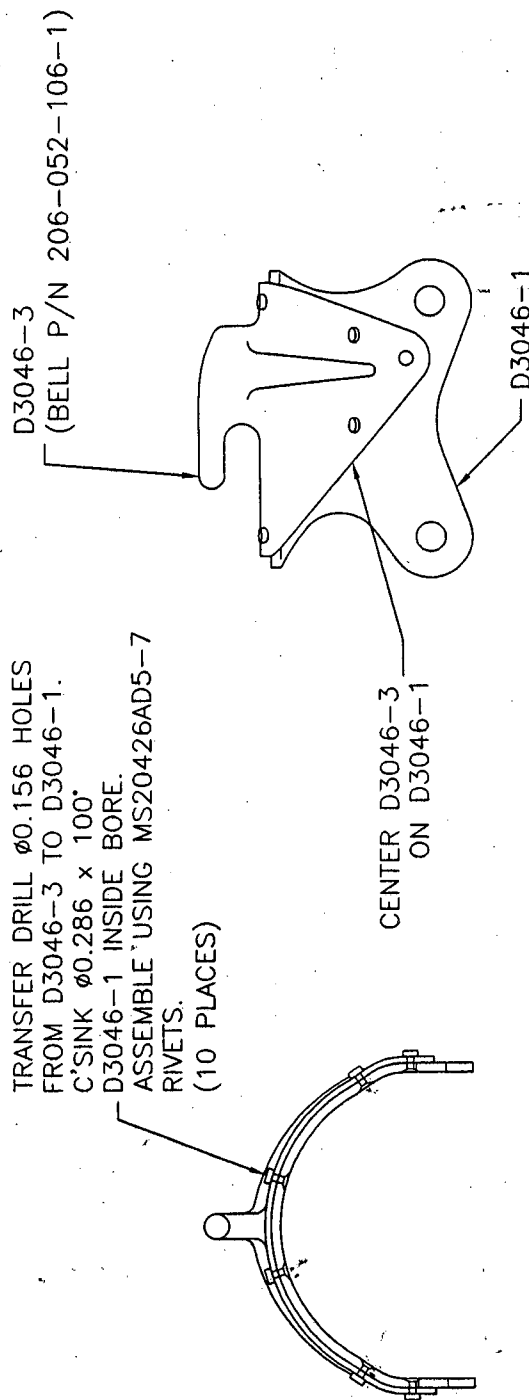
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. A SHEET 1 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2
A	01.08.23	NEW ISSUE	



D3046-041 LUG BRACKET ASSEMBLY

POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
RE-POWDER AFTER ASSEMBLY.
REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

NOTES:
1. FINISH TO BE AS SPECIFIED.
2. UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23688

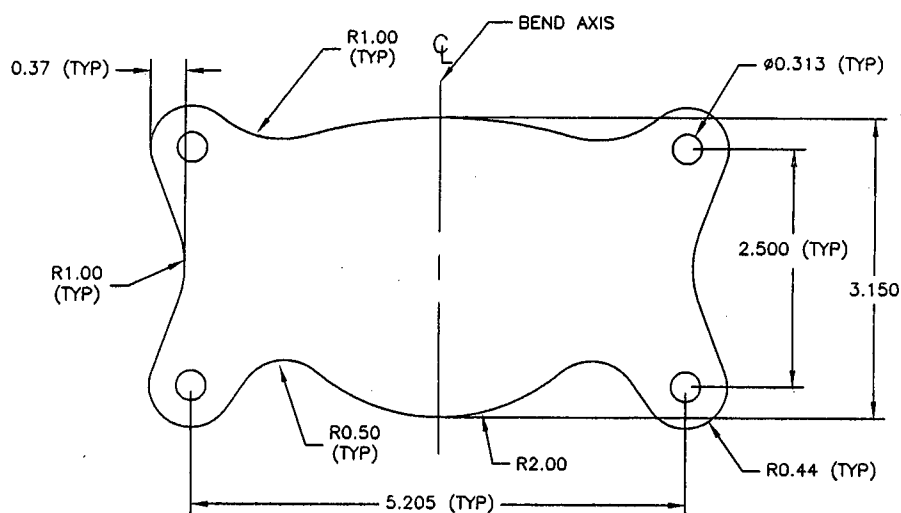
RELEASED
01.08.27

Copyright © 2001 by DART AEROSPACE LTD

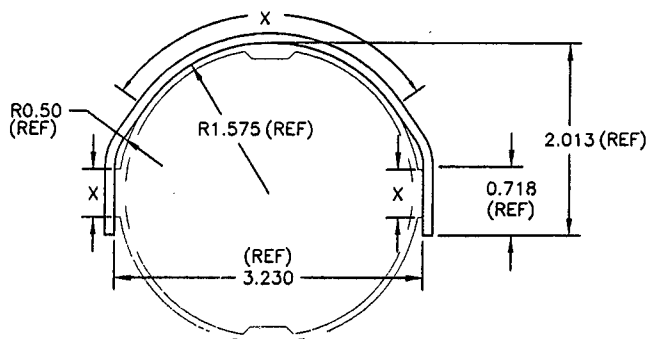
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (C)



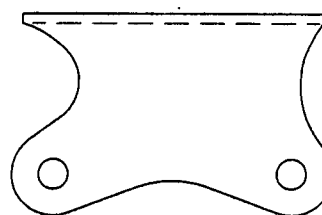
D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 23688

RELEASED
01.08.27

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

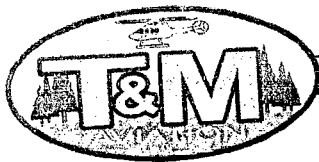
Jun 27, 2005
08:10 am

Work Order No : 0023688
Project Name : D3046-041
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D3046-041
Description : Lug Bracket
Manufactured : Yes
Amount Req'd : 14
Amount Done : 6
Start Date : 06-27-05
Est Finish Date : 07-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



112 Irish Bend Drive • Youngsville, LA 70592 • Bus (337) 893-9074 • Fax (337) 893-9101

June 23, 2005

Dart Helicopter Services
Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

RE: R390

Dear Peggy,

Please exchange the "L" model ground handling brackets P/N D2659 for the D3046-041 brackets. We need to be able to use OH-58 type ground handling wheels. We are sending the D2659 brackets back for credit against the purchase of the D3046-041 brackets. We are sending our existing OH-58 ground lugs (qty 4).

Please advise on price and timing as the aircraft is currently in the shop and unable to be moved until we get the wheel brackets replaced.

Please call Dawn (337-893-9074) for credit card number when job is ready.

Thanks

A handwritten signature in cursive script that reads 'Ron'.

Ron Wolf

REFERENCE ONLY